

157256

Friday, February 17, 2017 1:31:29 PM

Setup Start *NS1*

Stop ***NS2***

Knob

g

知

Customer:

Run Start *NR1*

Stop *NR2*

Draw Nbr	Revision Nbr	
D2002	Rev A	

0.00

0.31

Memo

1-Turn as per folio FA005 & dwg

FOLIO REV: nila

DWG REV: A

2-Deburr as required

QC2- Inspect parts off machine FAI/FAIB

0.00

0.01

QC

Memo

Quality Control

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐						OTHER : ☐	

Work Order ID 157256

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157256

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Item ID: D2002-015

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Knob

Start Date: 2/21/2017 Start Qty: 8.00

8

Cust Item ID:

Required Date: 3/2/2017 Req'd Qty: 8.00

8

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120						29	0		DAS 45 17-3-6 9-89
QC	Memo	0.03							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130						29			DAS 9-89 MAR 05 2017
Packaging	Memo	0.01							
Packaging	LOCATION : GA								
140	QC21- Final Inspection - Work Order Release	0.00							
140									17/3/8
QC	Memo	0.13							
Quality Control									DAS 21 9-89 MAR 08 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coor. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
340 34 38-2								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐			

Picklist Print

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Page 1

Work Order ID: 157256

157256

Parent Item: D2002-015

D2002-015

Parent Item Name: Knob

Start Date: 2/21/2017

Required Date: 3/2/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP C00.05.18Added inspection level 8EC
IPP Rev:D Now on Doosan Lathe JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.2500		Purchased		No		100	f	11.5050	0.05	0.4			

MDFI RINR1 2500

DEL RIN ROUND BAR 1.25" color: black

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT039	11.505	
m135214	1.025	
m135622	2.48	
m136552	8	

1.479 17-03-06

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

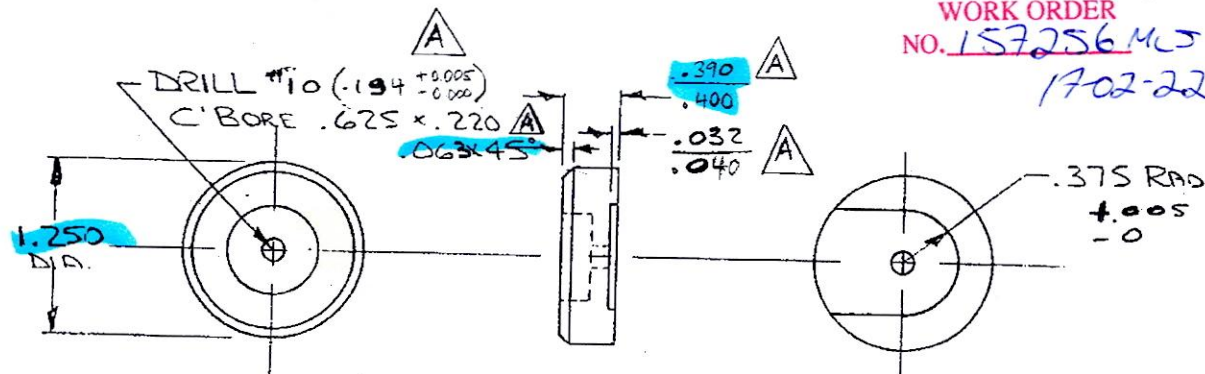
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157256 MJS

RELEASED

79.12.09 DS

1702-22



DETAIL OF D2002-015

4/F. BLACK DELRIN OR
BLACK UHMW PER D2689



D2002-015

REVISION DRAWN CHECKED APPROVED OF CHANGE		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 623		QTY. REQUIRED		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC. VENDOR							
ADD JHMV 1702-22		REQUIREMENTS - UNLESS OTHERWISE SPECIFIED GENERAL 1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS IN FINISHES SHARP EDGES 0.18 MAX. 3. THREADS PER MIL. S. 3743 4. HOLE PER MIL. 10287		LIMITS 1. TOLERANCES - AS SHOWN 2. ANGLES - 30° & 0-90° 3. PARALLELISM 4. PERPENDICULARITY 5. SYMMETRY ABOUT ALL HOLE CENTRE LINES 0.05		BASIC CODE DIMENSIONALITY OF DIMENTS C-COUNTERSINK BASIC CODES 1. HOLE 2. HOLE 3. HOLE 4. HOLE 5. HOLE 6. HOLE 7. HOLE 8. HOLE 9. HOLE 10. HOLE 11. HOLE 12. HOLE 13. HOLE 14. HOLE 15. HOLE 16. HOLE 17. HOLE 18. HOLE 19. HOLE 20. HOLE 21. HOLE 22. HOLE 23. HOLE 24. HOLE 25. HOLE 26. HOLE 27. HOLE 28. HOLE 29. HOLE 30. HOLE 31. HOLE 32. HOLE 33. HOLE 34. HOLE 35. HOLE 36. HOLE 37. HOLE 38. HOLE 39. HOLE 40. HOLE 41. HOLE 42. HOLE 43. HOLE 44. HOLE 45. HOLE 46. HOLE 47. HOLE 48. HOLE 49. HOLE 50. HOLE 51. HOLE 52. HOLE 53. HOLE 54. HOLE 55. HOLE 56. HOLE 57. HOLE 58. HOLE 59. HOLE 60. HOLE 61. HOLE 62. HOLE 63. HOLE 64. HOLE 65. HOLE 66. HOLE 67. HOLE 68. HOLE 69. HOLE 70. HOLE 71. HOLE 72. HOLE 73. HOLE 74. HOLE 75. HOLE 76. HOLE 77. HOLE 78. HOLE 79. HOLE 80. HOLE 81. HOLE 82. HOLE 83. HOLE 84. HOLE 85. HOLE 86. HOLE 87. HOLE 88. HOLE 89. HOLE 90. HOLE 91. HOLE 92. HOLE 93. HOLE 94. HOLE 95. HOLE 96. HOLE 97. HOLE 98. HOLE 99. HOLE 100. HOLE		APPROVAL		CONTRACT NO.		DATE		CLIENT		TITLE		CODE		DWG. NO.		REV.	
REPORT ALL DISCREPANCIES - DO NOT SCALE		DART AERO ACCESSORIES INC		KNOB		D2002		1:1		1 OF 2		1 OF 2		1 OF 2		1 OF 2		1 OF 2					